

Del 1.25

Work Order ID 78842

78842

Page 1

January-16-12 1:52:36 PM

Item ID: D3417-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer
 Start Date: 16/01/2012 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 30/01/2012 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/16 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|-------------------------|
| D3417 | Rev <u>E</u> / <u>F</u> |

| | | | | | | | | | |
|--------------|---|------|----|---------|--|----|---|--|--|
| 100 | Hardinge CNC LATHE SMALL | 0.00 | | | | 40 | 0 | | |
| *100* | | | | | | | | | |
| Doosan | Memo | 0.00 | | | | | | | |
| Doosan Lathe | 1-Turn as per Folio FA761 Rev: <u>E</u> & Dwg D3417 Rev: <u>F</u> 2-Deburr | | SD | 12/1/22 | | | | | |

| | | | | | | | | | |
|-----------------|---|------|----|---------|--|----|---|--|--|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | 40 | 0 | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | SD | 12/1/22 | | | | | |

| | | | | | | | | | |
|-----------------|-----------------------------------|------|----|----------|--|----|---|--|--|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | 41 | 0 | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | OK | 12/01/23 | | | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78842

January-16-12 1:52:36 PM

78842

Page 2

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Revision ID: Stop ***NS2***
Item Name: Washer
Start Date: 16/01/2012 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 30/01/2012 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location ST42. | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(41x) SP 12 01-23.

12/1/23

PL 12-01-23
(40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

January-16-12 1:52:40 PM

Page 1

Work Order ID: 78842

78842

Parent Item: D3417-5

D3417-5

Parent Item Name: Washer

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New issue 08-07-09 JLM Verified By: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MDEL RINR1.2500 | | Purchased | No | | | 110 | f | 25.4490 | 0.0296 | 1.246316 | | | |

MDFI RINR1 2500

DEL RIN ROUND BAR 1.25"

**

SD 12/1/22

Location

Loc Qty

Loc Code

MAT055

25.449

114586

1.449

119133

24

1.5

1.25

1.5

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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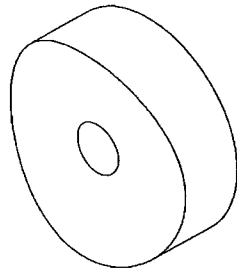
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

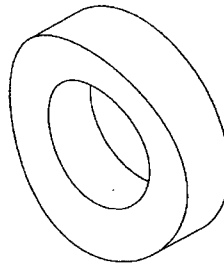
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NOTE: Date & initial all entries

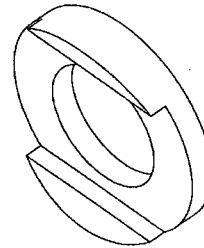
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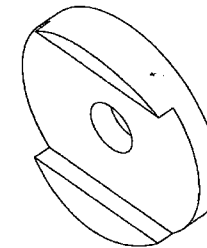
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



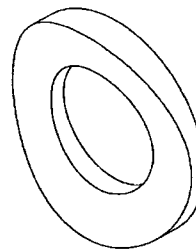
D3417-7 WASHER

SHC
RIT
FNCM
UNCONT
SUBJECT

WT
WT
NO. 78842 M.C.J.
12/01/16

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs



D3417-9 WASHER



RELEASED
2010-09-15
WJ

| | | | |
|------------|--|--|--------------|
| F | ADD D3417-8 (ZN B5-3) | SC | 10.07.26 |
| E | ADD D3417-7 (ZN A2-2) | RF | 09.06.30 |
| D | ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING | AJS | 08.07.08 |
| C | REMOVE CBORE, WIDEN | PH | 05.06.30 |
| B | CHANGE TO ROUND WASHER | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.03.31 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | SC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D3417 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WASHER | NTS |
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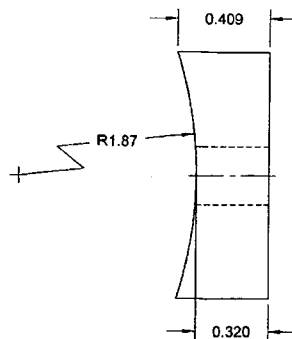
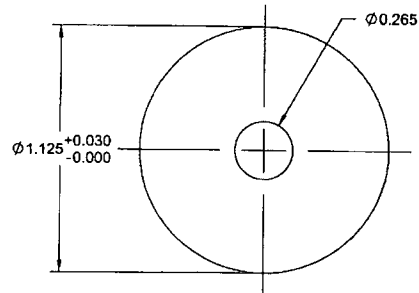
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

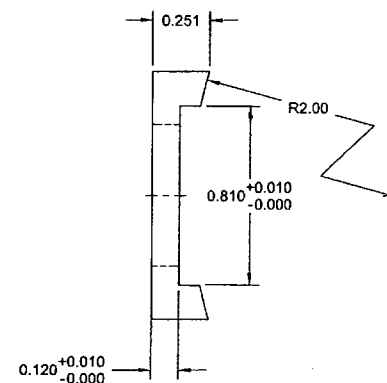
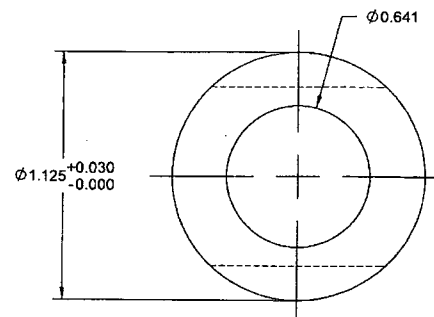
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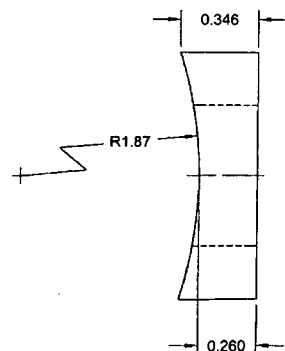
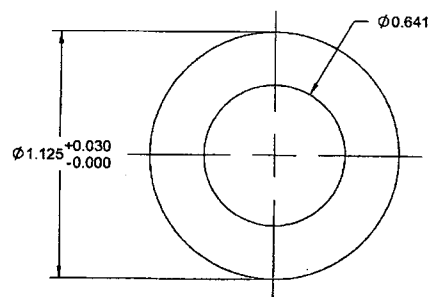
78842



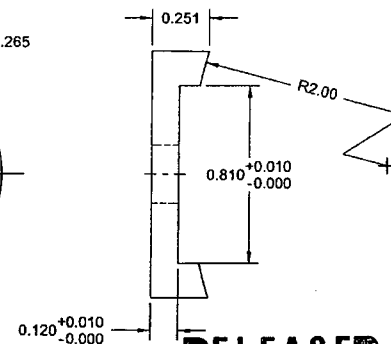
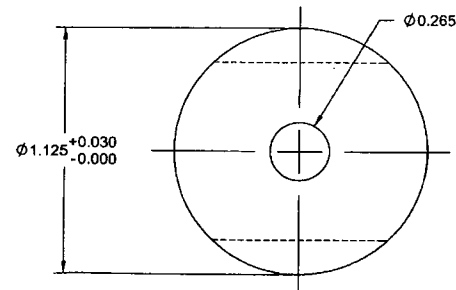
D3417-1 WASHER



D3417-5 WASHER



D3417-3 WASHER



D3417-7 WASHER

RELEASED
2010-09-15

| | | | |
|------------|----------|--|--------------|
| DESIGN | SC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D3417 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WASHER | NTS |
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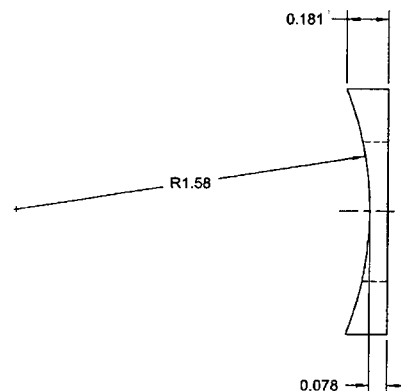
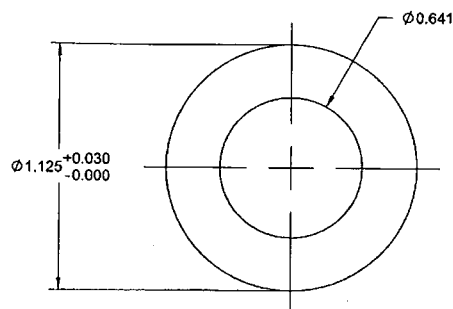
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NOTE: Date & initial all entries

78842



D3417-9 WASHER



RELEASED
2010-09-15

| | | | |
|------------|----------|--|--------------|
| DESIGN | SC | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D3417 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WASHER | NTS |
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